



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3068-3

Job Sheet 209993



Part No: D3068-3

Job Qty: 12 pcs

Part Name: Spacer



Part Weight: 0 lbs

Job Created: 5/21/20

Due Date: 6/1/20

Type: SOLD

Status: New

Job Tracking No:

Created By: Marie Lajeunesse

Priority: Medium

Description:

Note: DWG D3068 REV.A1 IPP RevA: New issue U/R DD verified by:EC
Ship Via:

~~UNDER REVIEW~~

POSITIVE RECALL

EFFECTIVE 20/05/20 AUTH SN

RELEASED PS DATE 20/05/20

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
110	Waterjet - Flow - 1	12 pcs		5/30/20	0.00	0.80	Waterjet - Flow			on 20/05/20
120	QC 2	12 pcs		5/30/20	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			on 20/05/20
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 66			
							QC 2 - 64			

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				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
130 QC 8	12 pcs	5/30/20	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
140 Small Fab - 2 - B4B	12 pcs	6/1/20	0.00 0.60	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
150 QC 5	12 pcs	6/1/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	

DAS

MAY 28 2020 40
9-89

MAY 28 2020

5/21/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

160 Packaging 3-1 - Stock -
B4B12
pcs

6/1/20

0.00 0.00

QC 5 - 51

QC 5 - 58

QC 5 - 68

QC 5 - 9

QC 5 - 50

QC 5 - 30

QC 5 - 40

QC 5 - 61

QC 5 - 81

QC 5 - 82

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B ✓

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

Packaging 3 - 37 - B4B

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 9

DAS

40

MAY 29 2020 9-89

DAS

80

9-89

MAY 29 2020

POSITIVE
RECALLPD
20-05-28See
Part Draw

170 QC 21 - SA

12
pcs

6/1/20

0.00 0.00

DAS

21

9-89

MAY 29 2020

Part Op 110 - 1-Cut as per DWG. DWG. Rev: A1PROG. Rev: A1 2-Deburr if necessary

Descriptions: 120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - C'SINK HOLES AS PER DWG

150 - QC5- Inspect part completeness to step on W/O

160 - ID AND STOCK

170 - QC21- Final Inspection - Work Order Release

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRINS0.125	Black Delrin Sheet .125	.2880 sf (.024 ea)	110-Waterjet - Flow - 1	5253969

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	MDELRINS0.125	0	20	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	1.720Inches $\pm$ 0.030	1.750 1.690		1.724
2	Spacer	0.860Inches $\pm$ 0.030	0.890 0.830		.861
3	Spacer	0.250Inches $\pm$ 0.005	0.255 0.245		.252
4	Spacer	1.480Inches $\pm$ 0.005	1.485 1.475		1.478
5	Spacer	1.980Inches $\pm$ 0.030	2.010 1.950		1.985
6	Spacer	0.098Inches + 0.005 - 0.000	0.103 0.098	Diameter	7.100
7	Spacer	0.188Inches $\pm$ 0.005	0.193 0.183	Diameter	.188
8	Spacer	100.000Degrees $\pm$ 0.000	100.000 100.000		100.00
9	Spacer	0.130Inches $\pm$ 0.010	0.140 0.120	Radius	.13

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Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

☐

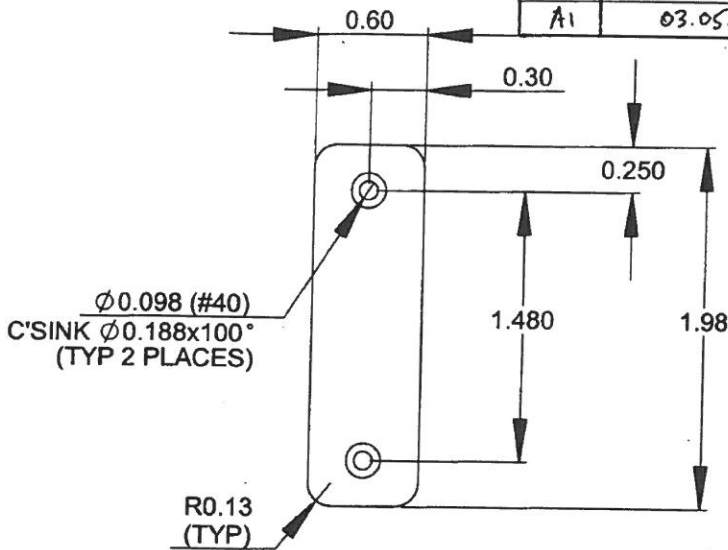
Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Rec/Store/Packaging ☐ Supplier ☐ Finishing ☐ Quality ☐																													
Date :		Sequence #:		QTY Affected :																													
Description Work Order Deviation		Disposition		MRB (QS1042)																													
				Completed By																													
				Lead hand / Supervisor																													
				QC / QA Coordinator																													
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>				Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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Mislabeled	Fit/Function	Off-set/Set-up																															
		Other/Details:																															

RELEASED
02.09.2011

DART

COPY ISSUED

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3068	REV. A SHEET 1 OF 1
DATE 02.09.11	TITLE SPACER		SCALE 1:1
A	02.09.11	NEW ISSUE	
A1	03.05.15	ADD M-DELIN-S PER NCR 700	



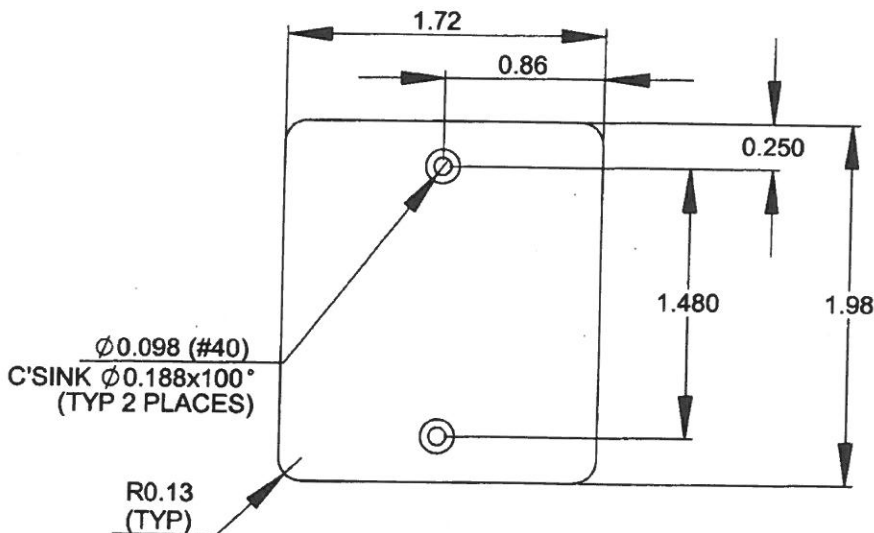
UNDER REVIEW

03.06.11

A1

D3068-1 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELIN-B OR M-DELIN-S 0.125 THICK
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



OBSOLETE

SUPERCEDED BY

15 14.07.28

A1

D3068-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELIN-B OR M-DELIN-S 0.125 THICK
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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